

Work Order ID 74605

Monday, October 03, 2011 4:02:30 PM

Page 1

Item ID: D2938-1

Accept-

Setup Start

Revision ID:

Stop

Item Name: Saddle LH Out, 206

Start Date: 10/3/2011 Start Qty: 6.00

Cust Item ID:

Required Date: 10/5/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2938	Rev C								

100

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

110

0.00



CONVENTIONAL MILLING MACHINE

0.00

Mill Conv

Memo

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

0.00



QC1- Inspect dimensions to dimension sheet

0.00

QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID: 74605



Page 2

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Revision ID:

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Item Name: Saddle LH Out, 206

Start Date: 10/3/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 10/5/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

will 9480

3200F

3:40

4:10

6X8 M/L 12/01/16

W/O:		WORK ORDER CHANGES					
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Page 3

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Start Date: 10/3/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 10/5/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

C BR 12-1-17

170

Identify as per dwg & Stock Location: SI 458A 0.00

Packaging

Memo

0.00

Packaging

OK - SP 12-01-23

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

12/1/23

12-01-23
G

W/O:		WORK ORDER CHANGES					
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Picklist Print

Monday, October 03, 2011 4:02:47 PM

Page 1

Work Order ID: 74605



Parent Item: D2938-1



Parent Item Name: Saddle LH Out, 206

Start Date: 10/3/2011

Required Date: 10/5/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B ☐ 00.06.26 ☐ New DWG rev (mpp 2069) ☐ EC
IPP Rev: C As per Rev C 07-03-19 JLM ☐ ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-003		Manufactured	No			100	Each	73.0000	1	6			
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Saddle Billet, 7075



B.A 12/01/11

Location

Loc Qty

Loc Code

MAT040

8

72226

8

MAT44

65

72226

5

73769

60

→ 76837

6.0

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD	Work Order: 74605
Description: 206 Saddle, Outboard, Left side	Part Number: D2938-1
Inspection Dwg: D2938 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions					
				1	2	3	4	5 By	6 Date
A	0.100	0.140		0.132	.125	.126	.125	.125	.125
B	0.100	0.140		0.130	.126	.127	.126	.125	.126
C	0.100	0.140		0.116	.118	.120	.120	.119	.119
D	0.210	0.230		0.224	.225	.224	.224	.224	.223
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		0.517	0.512	.512	.512	.512	.512
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		0.260	0.260	.257	.257	.257	.257
L	0.312	0.317		0.314	0.314	.314	.314	.314	.314
M	0.235	0.240		0.237	0.237	.237	.237	.237	.237
N	0.100	0.140		0.127	.122	.123	.123	.123	.121
O	0.540	0.560		0.549	.549	.549	.550	.549	.550
P	0.490	0.510		0.500	.503	.502	.500	.499	.499
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720	3.720
R	2.720	2.760		2.740	2.740	2.740	2.740	2.740	2.740
S	0.240	0.270		0.255	.254	.254	.254	.254	.254
T	0.100	0.180		0.135	0.135	.135	.135	.135	.135
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		0.316	0.316	.316	.316	.316	.316
X	1.250	1.270		1.259	.1259	1.260	1.260	1.260	1.260
Y	1.565	1.585		1.574	1.574	1.575	1.575	1.575	1.575
Z	0.178	0.198		0.188	0.188	.188	.188	.188	.188
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: B.A.	/ 12-01-12
Date: 12/01/11	

Audited by: [Signature]
Date: 12/01/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	[Signature]

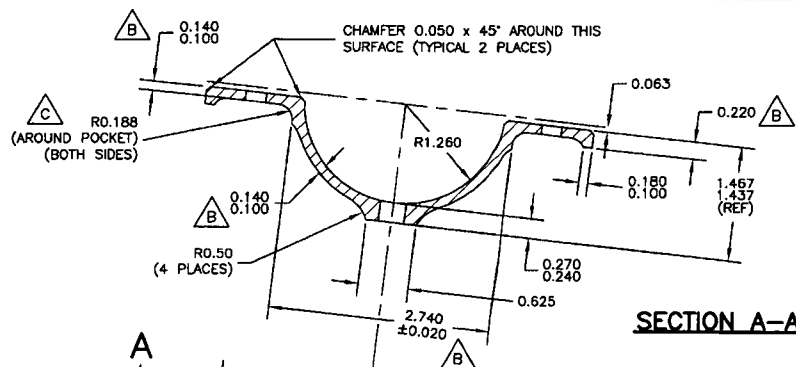
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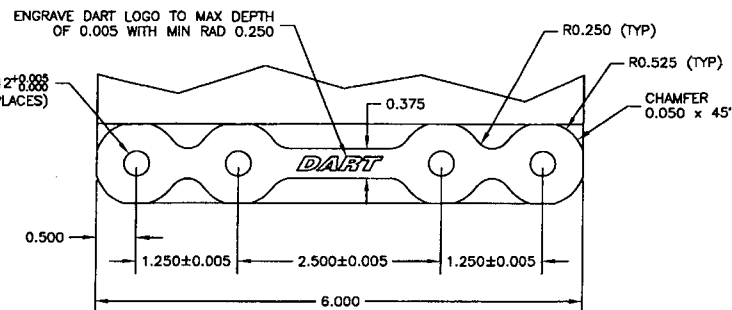
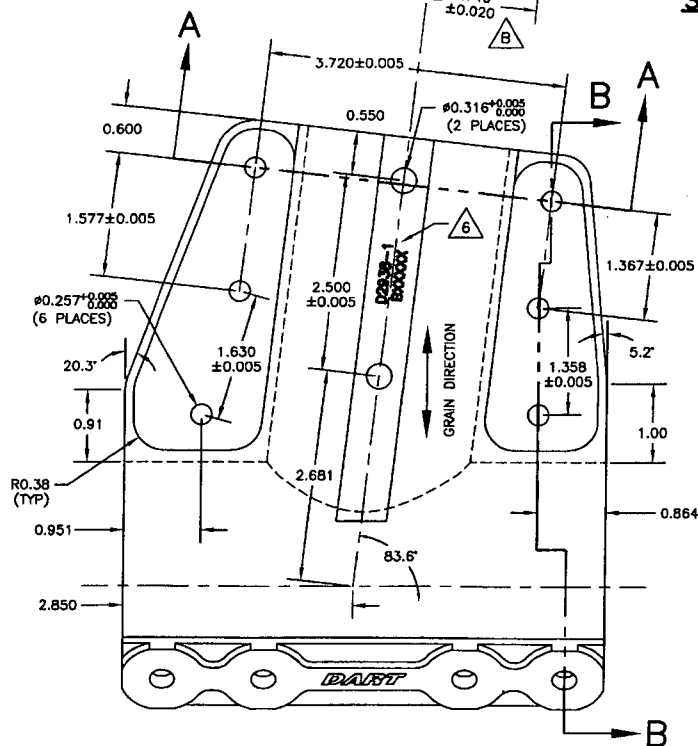
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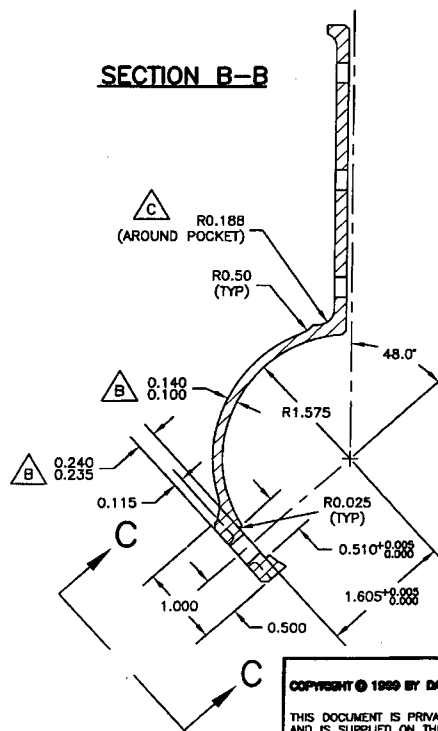


SECTION A-A



VIEW C-C

SECTION B-B



14605 11-10-4

D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)

- NOTES:
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12) (MAKE FROM D6101-003 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	CB	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	PH	DRAWING NO. D2938
DATE	06.11.09	TITLE SADDLE OUTSIDE
		REV. C SHEET 1 OF 1 SCALE 2:3

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07.02.12

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